

Work Order ID 86206 - 1

86206

Page 1

Item ID: D4072-5

Revision ID:

Item Name: Bushing

Start Date: 22/06/2012 Start Qty: 40.00

Required Date: 06/07/2012 Req'd Qty: 40.00

Reference:

Approvals: Process Plan: *MLJ*

QC:

Date: *12/06/22*

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D4072 B

100

1000

Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

1-Turn as per Dwg and Folio FA978

Dwg Rev: *B*

Folio Rev: *AA*

2-Deburr

0.00

0.00

AS
14
9-89

12/07/30

32

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

DAS
14
9-89

12/07/30

32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & Initial all entries

Work Order ID 86206

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June-22-12 3:04:43 PM

Item ID: D4072-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 22/06/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 06/07/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

24 12-7-30 32

32

12/7/31

12/8/11

MCS 12/07/31

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-22-12 3:04:47 PM

Page 1

Work Order ID: 86206

86206

Parent Item: D4072-5

D4072-5

Parent Item Name: Bushing

Start Date: 22/06/2012

Required Date: 06/07/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED BY:DD IPP
REV:B DRAWING REV. CHANGE AS PER ECN 11-598 11-07-05 JFS
VERIFIED BY:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500		Purchased	No			100	f	263.8920	0.03	1.263158			

M303R0 500

**

303 Round Bar 0.500"

Location	Loc Qty	Loc Code
MAT028	263.892	
117143	11.34	
118509	1.36	
119009	137.705	
119616	36.737	
→ 121728	76.75	

1.024 on 12/07/30

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

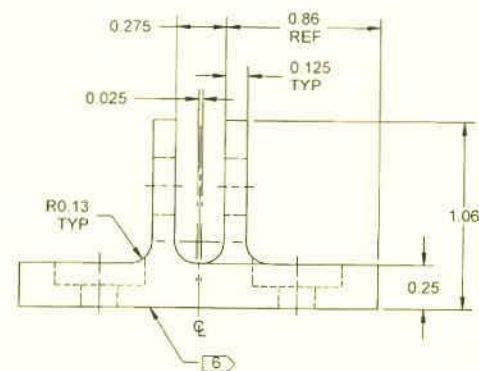
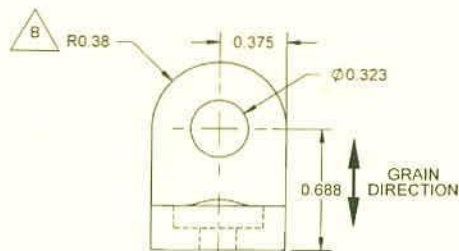
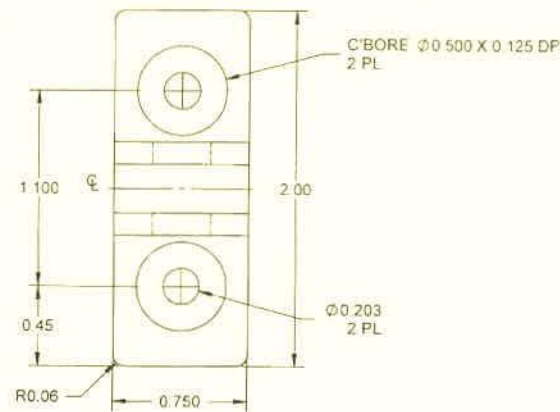
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 86206 MLJ
12/06/22

D4072-1 AIRFRAME HINGE

RELEASED
2011-06-30
AM

NOTES

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

B	CORRECT TYPO (ZN B7-1)	RF	10.11.02
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4072	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	AIRFRAME HINGE	NTS
DATE	10.11.02	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.	
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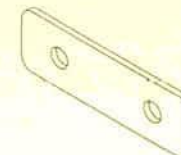
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

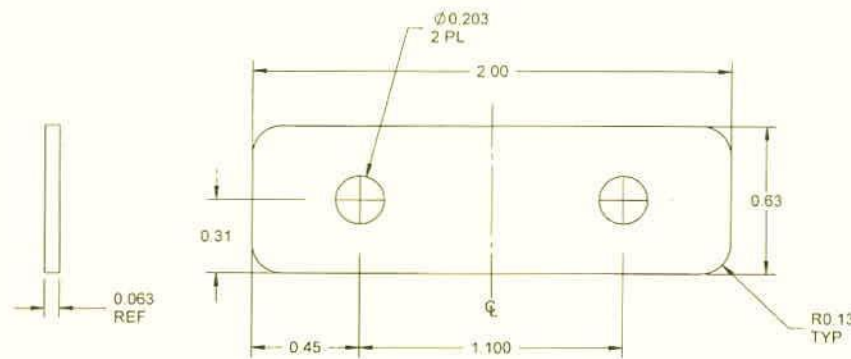
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NOTE: Date & initial all entries



86206



D4072-3 AIRFRAME HINGE BACKING PLATE

RELEASED
2011-06-30

NOTES

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S 063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV B
MFG APPR	RF	D4072	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR	RF	AIRFRAME HINGE	NTS
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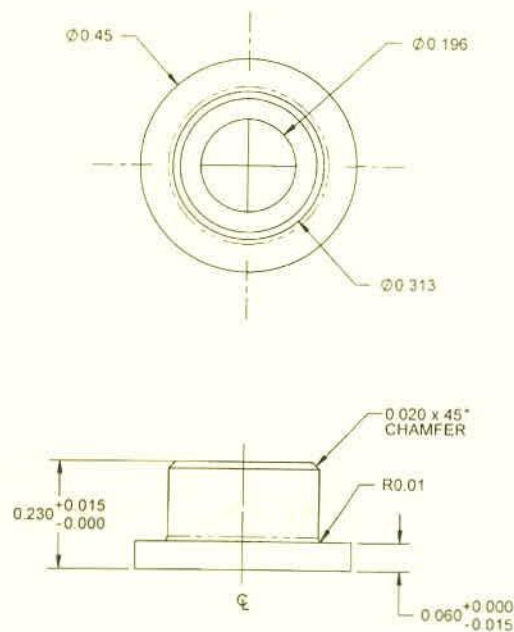
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4072-5 BUSHING



86706

RELEASED
2011-06-30

NOTES

- 1) MATERIAL: AISI 303 STAINLESS STEEL BAR
REF DART SPEC. M303B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI Q44 6.1
- 7) WEIGHT: 0.004 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4072	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AIRFRAME HINGE	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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